

**Work Order ID 59188**

Thursday, May 27, 2010 1:21:07 PM



Page 1

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, RH)

Stop



Start Date: 5/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10-5-27*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								

D3838	Rev A
-------	-------

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open  
to finish size as per dwg D3838A/R ER316 S.S. Rod Batch: *M108775*

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: *M108775*

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

(2) 10.06.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

110



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

S wba10

+2

-042

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

L C 10-06-10

130



Packaging

Packaging

Identify as per dwg &amp; Stock Location: WA

0.00

0.00

SA10 10-06-10

(Q)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

140

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC

Quality Control

Memo

0.00

10/06/11  
MF

10-6-10

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# Picklist Print

Thursday, May 27, 2010 1:21:10 PM

Page 1

Work Order ID: 59188



Parent Item: D3838-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 		Manufactured	No			100	Each	114.0000	1	2		RD 10.06.10	

Bushing

Location	Loc Qty	Loc Code
WA	114	
54072	9	
58159	1	
58256	26	
58581	42	
58672	36	

M304TS0.750W.065

Purchased

No

304 SQ Tube .75x.75x.065W

Location	Loc Qty	Loc Code
MAT	187.1361	
112398	0	
114482	187.1361	
WA	1000	
114520	1000	

RD 10.06.10

RD 10.06.10

2.172

110

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8

7

6

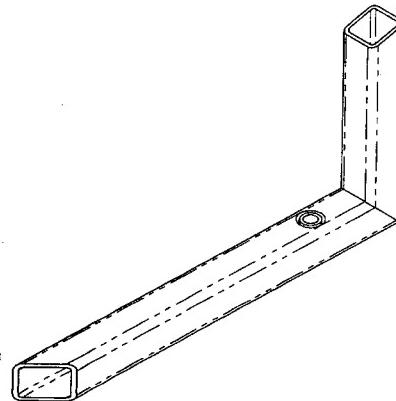
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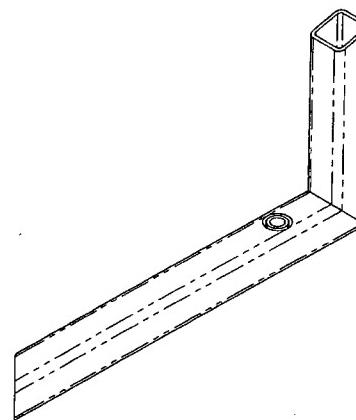
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1



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

A  
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

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UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 59188

*BD 10-5-27*

RELEASED  
*(08/11/18 MM)*

A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>b</i>	DART AEROSPACE LTD	
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>b</i>	DRAWING NO. D3838 REV. A	
MFG. APPR.	<i>b</i>	SHEET 1 OF 3	
APPROVED	<i>b</i>	TITLE	SCALE
DE APPR.	<i>b</i>	RIB ASSY (BASKET LID) NTS	
DATE	08.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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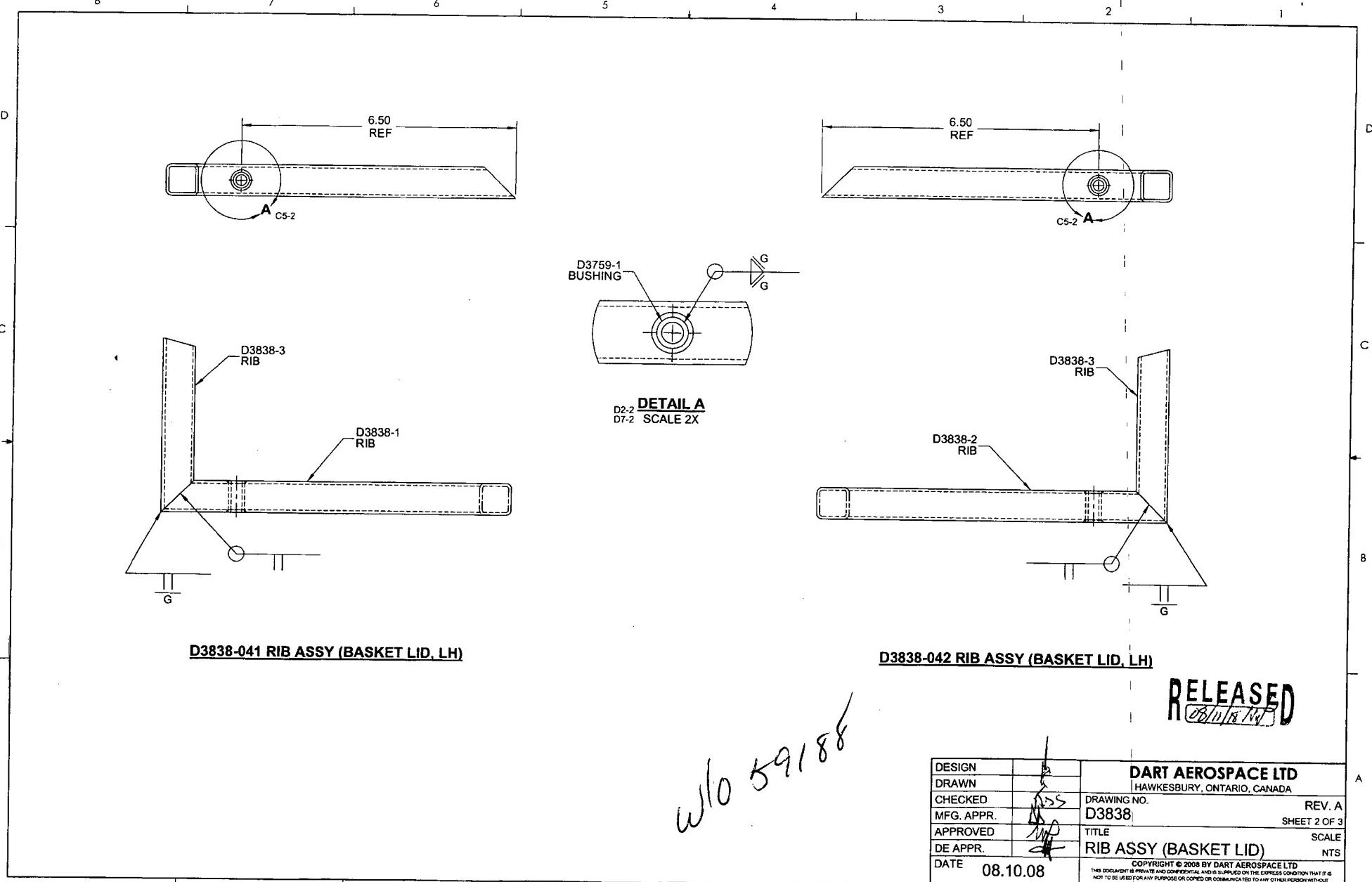
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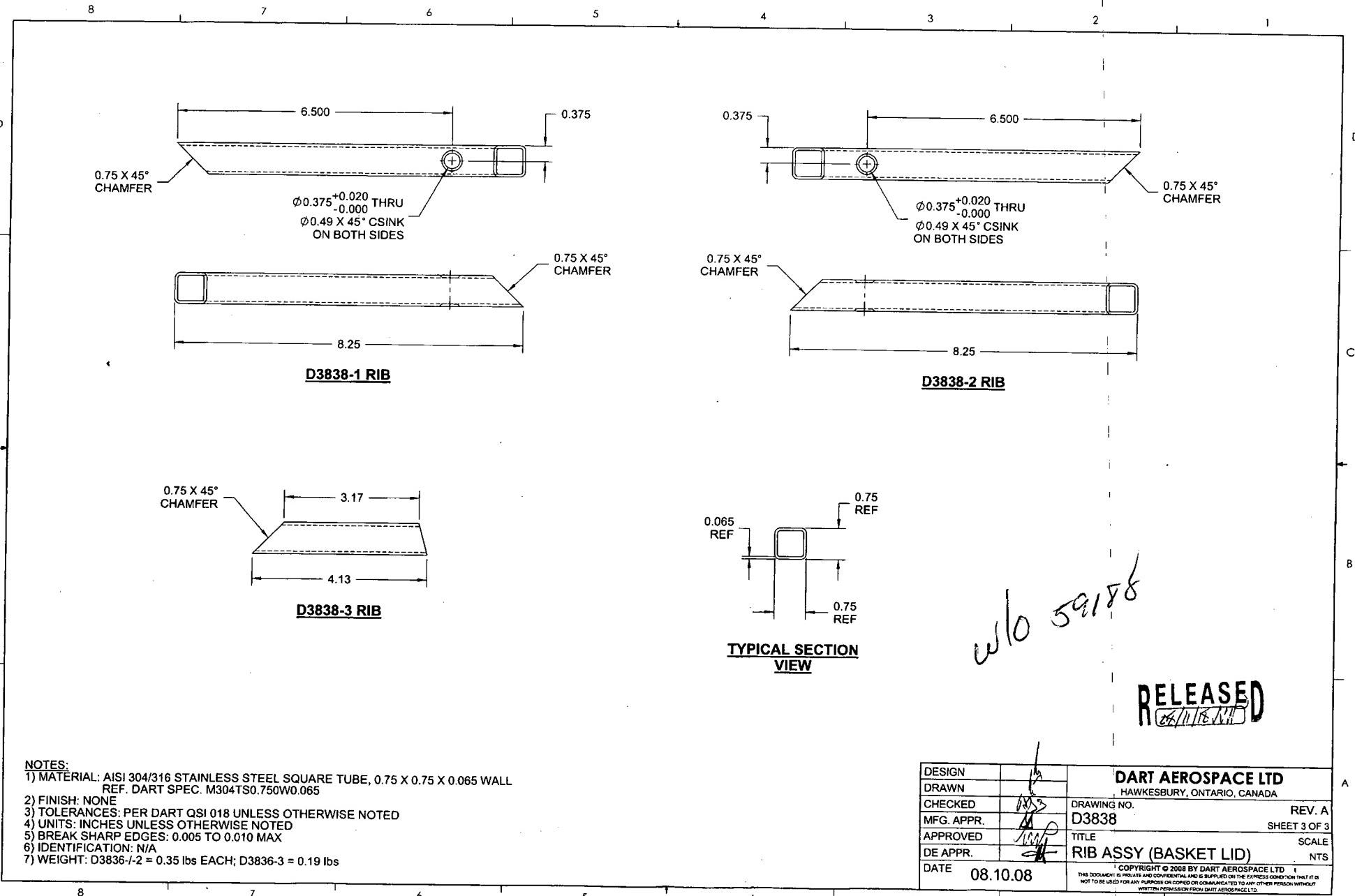
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